

Date: Wednesday, 18/04/2007 8:20:39 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: COVER	
Job Number	: 31658		Part Number	: D32021	
Estimate Number	: 10287		Drawing Number	: D3202 REV B1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 18/04/2007	S.O. No. : N/A	Drawing Revision	: B1	
Prsh't Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 30/04/2007 Qty: 12 Um: Each	
Previous Run	: 31658				
Written By	: <u>Linda Lacelle</u>				
Checked & Approved By	: <u>Linda Lacelle</u>				
Comment	Est Rev:B	No Longer Made In House	05-11-06	JLM	
	Est Rev:C	Now on Waterjet	07-04-18	JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S032	5052-H32.032 Sheet
	Comment: Qty.: 1.6286 sf(s)/Unit Total : 19.5426 sf(s) 5052-H32.032 Sheet Batch: <u>M100470</u>	<u>M1 07 05 25</u> (12)
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3202 Dwg Rev: <u>B1</u> Prog Rev: <u>B1</u>	<u>M1 07 05 25</u> (12)
	2-Deburr if necessary	<u>M1</u> 07-05-29 (12)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>M1 07 05 25</u> (12)
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	<u>JACUS-28</u> (12)
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	<u>H28</u> 07-05-29 (12)

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Seq. #:	Machine Or Operation:	Description :
6.0	POWDER COATING	POWDER COATING <i>m 101601</i>
		<i>BR/ am</i> <i>07/05/30</i> <i>(12)</i>
Comment: POWDER COATING	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	
7.0	QC3	INSPECT POWDER COAT/ CHEMICAL CONVERSION <i>7/5/30 59</i>
Comment: INSPECT POWDER COAT/ CHEMICAL CONVERSION		
8.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>SP</i>
		<i>2/5/30</i> <i>CC</i> <i>(12)</i>
Comment: PACKAGING RESOURCE #1	Identify and Stock Location: <i>ST 221</i>	
9.0	QC21	FINAL INSPECTION/W/O RELEASE <i>1/5/30 SP</i>
		<i>05/10/01</i> <i>(12)</i>
Comment: FINAL INSPECTION/W/O RELEASE		

Job Completion



NOV 05/31

Date: Thursday, 4/12/2007 8:21:58 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: COVER		
Job Number	: 31658		Part Number	: D32021		
Estimate Number	: 10287		Drawing Number	: D3202 REV B1		
P.O. Number	:		Project Number	: N/A		
This Issue	: 4/12/2007	S.O. No. :	Drawing Revision	: B1		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: PURCHASED PARTS			
Previous Run	: 25557F		Due Date	: 4/30/2007		
Written By	:		Qty:	12	Um:	Each
Checked & Approved By	:		04/07/04.12			
Comment	: Est Rev:B		No Longer Made In House		05-11-06	JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	PG	PURCHASING <i>MS0521135032</i> Comment: PURCHASING Issue P/O: _____ E-mail or Ship DXF file to vendor Laser cut flat pattern as per Dwg Possible supplier: Ind. Laser Material realease note is required.
2.0	D32021F	Cover Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
3.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached
4.0	QC6	DIMENSIONAL CHECK Comment: DIMENSIONAL CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:21:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 31658

Part Number: D32021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD	Work Order:	31658
Description: Cover	Part Number:	D3202-1
Inspection Dwg: D3202 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

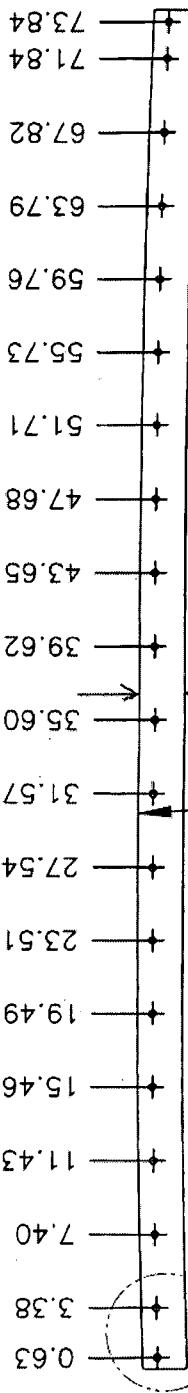
X First Article Prototype

Measured by:	M	Audited by:		Prototype Approval:	N/A
Date:	07/05/25	Date:	07/05/28	Date:	N/A

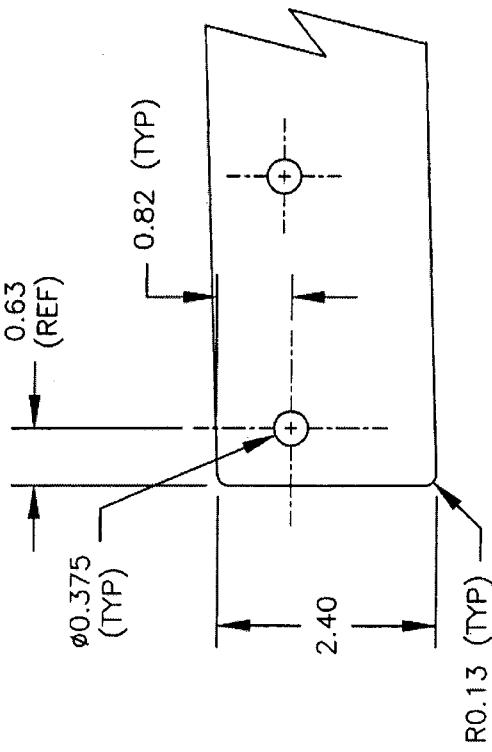
Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	06.09.28	Revised per Rev. B1	KJ/JLM	

DARTCOPY IS
ON THIS

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3202	SHEET 1 OF 1
DATE		TITLE	SCALE
03.10.16		COVER	1:10
A	01.01.01	NEW ISSUE	
B	03.10.16	REDESIGN; PART NOW CURVED	
1B	04.05.14	CLARIFY MID-SPAN DIMENSION	

**RELEASED**

03.11.07

DETAIL A
SCALE 1:2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31658

D3202-1 COVER

- 1) MATERIAL: 5052-H32/H34 SHEET (QQ-A-250/8) 0.032 THICK (REF DART SPEC. M5052H32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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